

# Work Order ID 55783

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Item ID: D2721-042

Accept

Revision ID:

Item Name: 206B Step Assembly

Start Date: 2/02/10 Start Qty: 2.00

Required Date: 2/18/10 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: *W* Date:

QC: Date:

Tooling: Date:

SPC (Y/N): Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr	Revision Nbr
D2721	Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Cut D2721-2 using D2622 extrusion as per Dwg D2721. Deburr and bevel ends for welding

*10.02.11*

*2* *Ø*

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld end cap (One End Only) and lugs as per Dwg D2721 using Jig DT followed by Jig DT 11A/R AL Rod Batch: *1110130* ☐ Grind *1111311*

*10.02.17*

*2* *Ø*

120

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

*2* *Ø*

*BE 10/02/17*

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Setup Start

Stop

Start Date: 2/02/10 Start Qty: 2.00

Required Date: 2/18/10 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 10/2/17

42  
RH

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10-02-17

2

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10-02-17

2

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Item ID: D2721-042

Accept



Setup Start



Revision ID:

Stop



Item Name: 206B Step Assembly

Start Date: 2/02/10 Start Qty: 2.00



Cust Item ID:

Required Date: 2/18/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160



Large Fab

Large Fab

0.00

Memo

0.00

Inspect for foreign object per QSI 024 Weld Remaining end cap as per Dwg  
D2721 using Jig DT followed by Jig DT A/R AL Rod  
Batch: mill 311 Grind End Cap Welds Flush

*10.02.18*

2

*φ*

170



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

2

*φ*

*BE 10/02/18*

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

*7 8/10/18*

*+2  
RH*

2

*φ*

*BE 10/02/18*

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Item ID: D2721-042

Accept

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Start Date: 2/02/10 Start Qty: 2.00

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

Chemical Conversion Coat per QSI005 4.1

0.00

BR 10-02-18 (2)

HandFinish

Memo

0.00

Hand Finishing

197

0.00

Powdercoat

Memo M. 113170.

0.00

Powder Coating

powder coat white per QSI 005

START 3:45  
OVEN 320°  
FINISH 3:15

BR 10-02-18

(2)

198

QC3 Inspect Part Finish

0.00

QC

Memo

0.00

MS 10/02/18

(K2) P

Quality Control

~~10-03-02~~

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Item ID: D2721-042

Accept

Setup Start

Revision ID:

Stop

Item Name: 206B Step Assembly

Start Date: 2/02/10 Start Qty: 2.00

Cust Item ID:

Required Date: 2/18/10 Req'd Qty: 2.00

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

220

Pressure Wash per QSI005 4.3

0.00



HandFinish

Hand Finishing

M100224

WING WALK BATH 113462

Memo

0.00

RK 1002-24

230

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

10102129

XZ

240

Identify as per dwg & Stock Location:

0.00



Packaging

Packaging

Memo

PPA 56509

0.00

PC 10/3/01

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Stop



Item Name: 206B Step Assembly

Start Date: 2/02/10

Start Qty: 2.00



Cust Item ID:

Required Date: 2/18/10

Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

250

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/03 *[Signature]*

*PS 10-3-02*

# Picklist Print

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Page 1

Work Order ID: 55783

Parent Item: D2721-042

Parent Item Name: 206B Step Assembly



Start Date: 2/02/10

Required Date: 2/18/10

Comments: IPP Rev:F As Per Ecn 766 06-01-06 JLM

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3461-7		Manufactured	No			100	Each	34.0000	2.0000			
												
Mounting Plate												

*PK 10.02.17*

D2622-120C		Manufactured	No			110	Each	48.7400	2.0000			
												
Step Extrusion												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	34	
33863	34	

2

*PK 10.02.11*

D2734		Manufactured	No			110	Each	79.0000	4.0000			
												
Step End Plate												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
WA	48.74	
48612	3.12	
52026	45.62	

2

*PK 10.02.18*

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	9	
43535	2	
48110	7	
Main Warehouse		
WA	70	
55014	70	

4

# Picklist Print

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Work Order ID: 55783

Parent Item: D2721-042

Parent Item Name: 206B Step Assembly


Comments: IPP Rev:F As Per Ecn 766 06-01-06 JLM

Start Date: 2/02/10

Required Date: 2/18/10

Start Qty: 2.00


Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3461-1  Mounting Plate		Manufactured	No			110	Each	13.0000	2.0000			

*10.02.17*

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	13	
<u>41600</u>	13	


2

D3461-3  Mounting Plate		Manufactured	No			110	Each	16.0000	2.0000			
---	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

*10.02.17*

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	16	
<u>41601</u>	16	

2

D3461-5  Mounting Plate		Manufactured	No			110	Each	32.0000	2.0000			
---	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

*10.02.17*

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	32	
<u>33862</u>	32	

2

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Shop Packet Print

Page 2



RELEASED  
05-11-14

APPLY BLACK  
ANTI-SKID ON  
- TOP SURFACE  
TO BOTTOM  
OF TOP RADIUS

- REFER TO STEP  
END DETAIL

D2721-1  
MAKE FROM EXTRUSION D2622-078

D2721-041 LH STEP ASSEMBLY (SHOWN)  
D2721-042 RH STEP ASSEMBLY (OPPOSITE)

ROUND CORNER OF EXTRUSION TO  
MATCH BEND RADIUS OF END PLATE

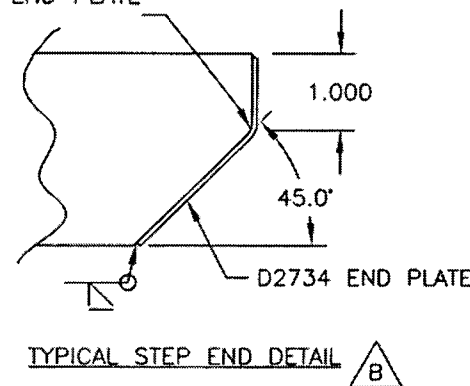
**D2721-041/-042 STEP ASSEMBLY PARTS LIST**

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2721-041	LH STEP ASSEMBLY
	X	D2721-042	RH STEP ASSEMBLY
1	1	D2822-078	EXTRUSION
2	2	D2734	END PLATE
1	1	D3461-1	PLATE
1	1	D3461-3	PLATE
1	1	D3461-5	PLATE
1	1	D3461-7	PLATE

D2721-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622 *RY-0-2-01*
- 2) WELD PER DART QSI 004 TYPICAL
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP  
RETURNED  
ENGINE  
UNCONTROLLED  
SUBJECT  
WITHOUT  
WORK  
NO. 55783  
RJ10-2-01



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